

SPLIT

ART AEROSPACE LTD	Work Order:	23263
Description: Driveshaft Tunnel Modification Kit	Part Number:	D412-705-015
Dwg: D3256 Rev. A	Qty:	12 Kit(s)

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PF	05.05.16	12
2	DC	Photocopy bluefile and create labels per PPP D412-705-015 CHG001	UK 21 JF	05.06.29	1
3	PG	Order (1) D3256-1 Issue P/O: 2006071 Email or Ship DXF file to vendor Laser Cut D3256-1 Flat pattern as per Dwg D3256 Material release note is required	U	05.05.17	12
4	RG	Receive and Inspect for transit damage Ensure material release note is attached	CL	05/06/08	12
5	QC6	Inspect dimensions for D3256-1 as per Dwg D3256	J	05.06.16	12
6	GA	Deburr if necessary	FF	05.06.23	12
7	GB	Form joggle using D3256-1T1 as per Dwg D3256	ml	05.06.27	12
8	GB	Form D3256-1 using D3256-1T2 as per Dwg D3256	ml	05.06.27	12
9	QC5	Inspect work for Step 8	Q	05.06.27	12
10	GA	Install D3256-3 gasket using 3M Scotch-grip adhesive as per Dwg D3256 Pick: Qty Part Number Description Batch 2 D3256-3 Gasket B23262 A A/R 1300/1300L 3M scotch-grip adhesive K17062 N/A FOR THIS W/O AS PER JL. INSTRUCTION			
11	GA	After curing transfer holes from D3256-1 into D3256-3 as per Dwg D3256 Identify as D3256-041	N/A		
12	QC5	Inspect work to Step 11	N/A		
13	KP	Pick: Packing Kit Qty Part Number Description Batch 1 D3256-041 Access Panel Assembly B23263 22 AN3C-3A Bolt K17204/A1776SL 3 AN3C-4A Bolt K175539 25 MS9321-09 Washer K17654 44 MS20427M3-3 Rivet K17654 22 MS21060-L3K Nut Plate K17654 CL 05/06/29 1			
14	QC4	Inspect Kit 100% for Completeness on the W/O	SB	05/06/29	1
15	PK	Identify and pack for shipping as per PPP D412-705-015	CL	05/06/29	1
16	AC	Cost / part 2929	AB	05/06/30	1
17	DC	Close W/O 2929 Inspect Level 21	PF	05.06.30	1

Rev	Date	Change	Revised By	Approved
A	04.03.25	New issue	KJ/RF	

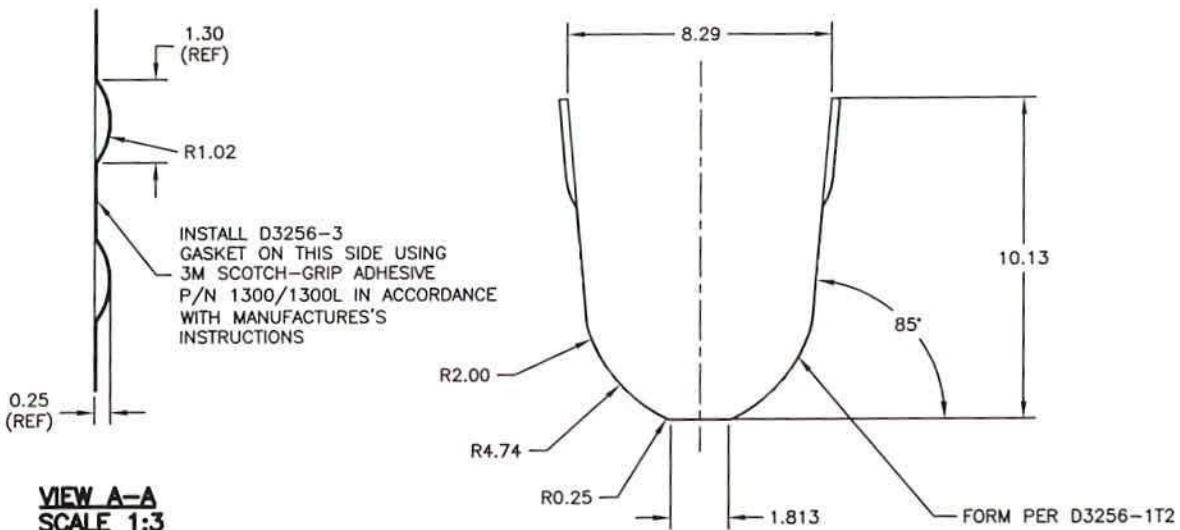
RELEASED
04.04.06

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
05.06.29	B	Shipping D3256046 only Not a complete list		u	05.06.29	1	u	PMB

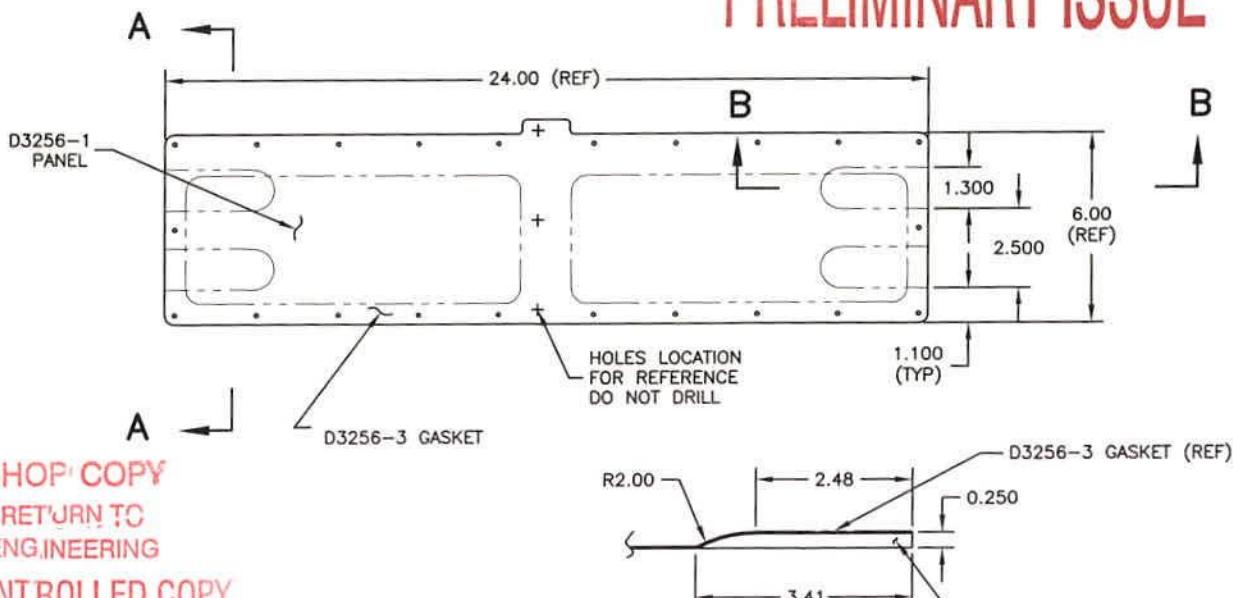
NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3256	REV. B SHEET 1 OF 3
DATE 05.06.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	05.06.27	D3256-3 DIM 1.30 WAS 0.65	



PRELIMINARY ISSUE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23263 A

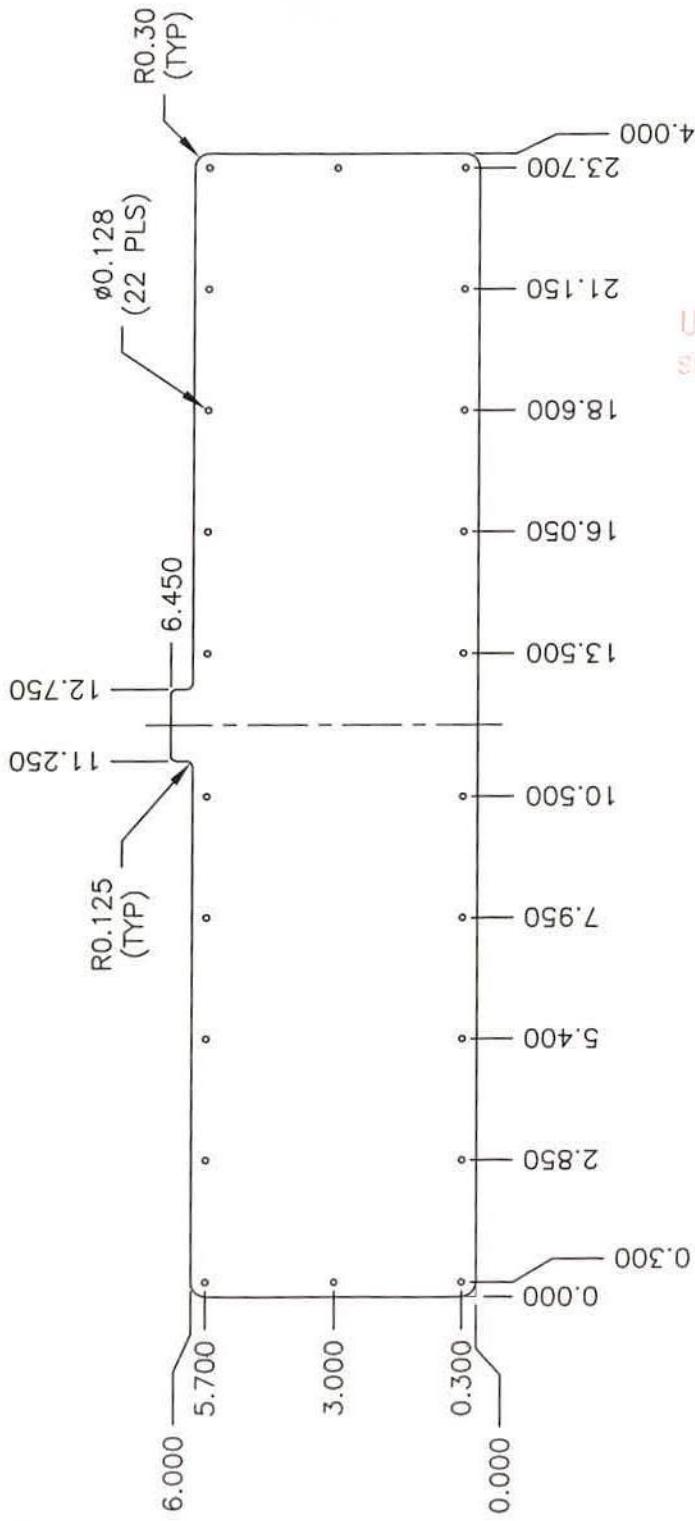
D3256-041 ACCESS PANEL ASSEMBLY

1) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3256	REV. B SHEET 2 OF 3
DATE 05.06.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23263 A

D3256-1 FLAT PATTERN

D3256-1 NOTES:

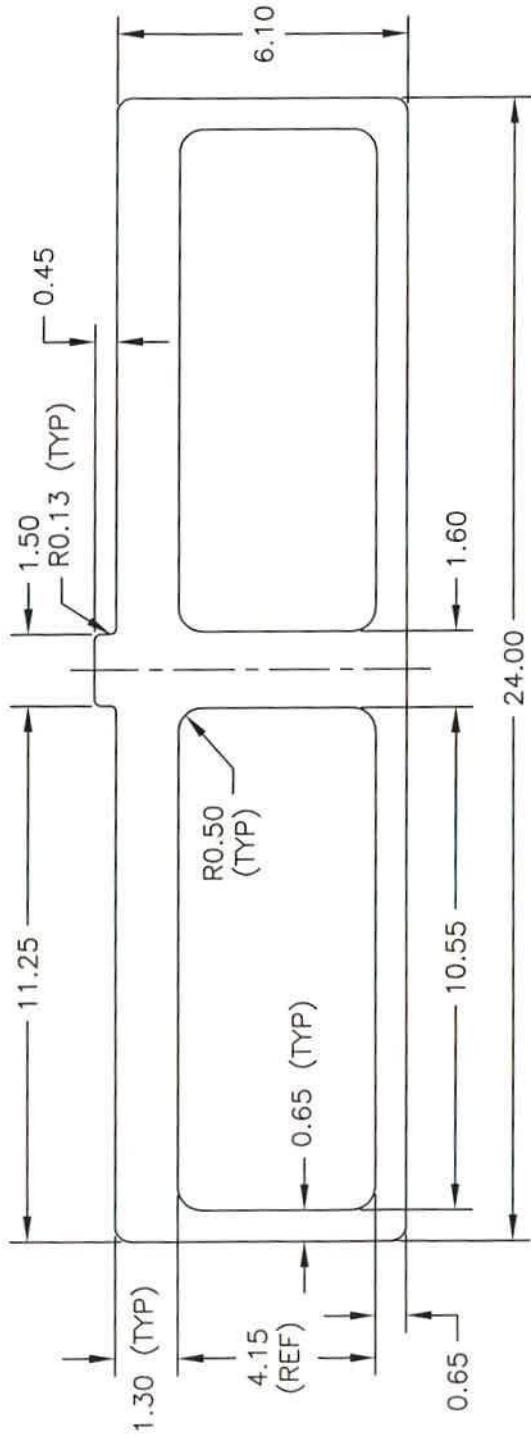
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

PRELIMINARY ISSUE

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3256
DATE 05.06.27		REV. B SHEET 3 OF 3 TITLE SCALE ACCESS PANEL ASSEMBLY 1:4



SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23263 A

D3256-3 GASKET

D3256-3 NOTES:

- 1) MATERIAL: DURABLA BLACK GASKET 0.035 THICK
MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2)
OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

PRELIMINARY ISSUE

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Linda Lacelle

From: "Brenda Leonard" <brendal@dartaero.com>
To: "Heather Mahon" <heatherm@dartaero.com>; "Jennifer Smith" <Jennifer@darths.com>
Cc: "Brigitte Golden" <brigitteg@dartaero.com>; "Linda Lacelle" <lindal@dartaero.com>
Sent: Tuesday, June 28, 2005 10:59 AM
Subject: Re: 8000839 * Shipping Instructions *

So if I understand correctly. I am to hold off shipping this order until you confirm.

Bren

----- Original Message -----

From: "Heather Mahon" <heatherm@dartaero.com>
To: "Jennifer Smith" <Jennifer@darths.com>
Cc: "Brigitte Golden" <brigitteg@dartaero.com>; "Brenda Leonard" <brendal@dartaero.com>; "Linda Lacelle" <lindal@dartaero.com>
Sent: Tuesday, June 28, 2005 10:55 AM
Subject: 8000839 * Shipping Instructions *

> I have clarified with Jason Loader DART Technical Support, (his comments are

> below) The Purchase Order 8000839 will still need to be shipped to
> Miami-Dade Fire Rescue once an amendment to the part is done.

>

> Heather

>

> ----- Original Message -----

> From: "Jason Loader" <jloader@eaglecopters.com>
> To: "Heather Mahon" <heatherm@dartaero.com>
> Sent: Tuesday, June 28, 2005 10:42 AM
> Subject: RE: D412-705-015

>

>

>> Hello Heather,

>> I'm sorry. I didn't mean to cause confusion, I should have worded my
>> message

>> better. They will still be getting a D3256-041, but with a different
>> gasket.

>> The shape of the gasket has been changed to fit better. Don't cancel the
>> PO,

>> just hold off on shipping anything until we have the panel with the new
>> gaskets available.

>>

>> Jason

>>

>> -----Original Message-----

>> From: Heather Mahon [mailto:heatherm@dartaero.com]
>> Sent: Tuesday, June 28, 2005 8:31 AM
>> To: Jason Loader

>> Subject: Re: D412-705-015
>>
>>
>> Hi Jason,
>>
>> Just so I understand.... I am not to send out P/N3256-041 to Miami Dade
>> then, I can cancel this PO? Will you be providing me with a new part
>> number?
>>
>> Heather
>>
>> ----- Original Message -----
>> From: "Jason Loader" <jloader@eaglecopters.com>
>> To: "Heather Mahon" <heatherm@dartaero.com>
>> Sent: Tuesday, June 28, 2005 10:18 AM
>> Subject: RE: D412-705-015
>>
>>
>>> That's good. I will talk to Roberto about getting the revised part sent
>>> to
>>> them instead.
>>> I will let you know as soon as we have it sorted out. I will also let
>>> Gerald
>>> know we will send this alternate part instead.
>>>
>>> Jason
>>>
>>> -----Original Message-----
>>> From: Heather Mahon [mailto:heatherm@dartaero.com]
>>> Sent: Tuesday, June 28, 2005 8:09 AM
>>> To: Jason Loader
>>> Subject: Re: D412-705-015
>>>
>>>
>>> Good morning Jason
>>>
>>> The Panel Assembly for Miami Dade did not go out yesterday. It is to go
>>> out
>>> today P1 overnight. (There was a delay with shipping)
>>>
>>> Heather
>>>
>>> ----- Original Message -----
>>> From: "Jason Loader" <jloader@eaglecopters.com>
>>> To: "Heather Mahon' (E-mail)" <heatherm@dartaero.com>
>>> Sent: Tuesday, June 28, 2005 9:54 AM
>>> Subject: FW: D412-705-015
>>>
>>>
>>>>
>>>> Good Morning Heather,

>>>
>>> Any news on this? If it hasn't left yet we could send him an alternate
>>> part
>>> that may work better for his installation.
>>> Jason
>>> -----Original Message-----
>>> From: Peggy McDonald [mailto:peggym@dartaero.com]
>>> Sent: Monday, June 27, 2005 6:05 PM
>>> To: Jason Loader
>>> Subject: Re: D412-705-015
>>>
>>>
>>> Check with Heather - I think it should have left today.
>>>
>>> Peggy
>>>
>>> ----- Original Message -----
>>> From: "Jason Loader" <jloader@eaglecopters.com>
>>> To: "Peggy McDonald" <peggym@dartaero.com>
>>> Sent: Monday, June 27, 2005 6:12 PM
>>> Subject: RE: D412-705-015
>>>
>>>
>>> Has this panel been sent yet?
>>>>
>>>> Jason
>>>>
>>>> -----Original Message-----
>>>> From: Peggy McDonald [mailto:peggym@dartaero.com]
>>>> Sent: Friday, June 24, 2005 1:38 PM
>>>> To: Bill Beckett
>>>> Cc: Dale Trepanier; Jason Loader
>>>> Subject: Re: D412-705-015
>>>>
>>>>
>>>> I will send to the order as a no charge to OE.
>>>>
>>>> Peggy
>>>>
>>>> ----- Original Message -----
>>>> From: "Bill Beckett" <billb@dartaero.com>
>>>> To: "Peggy McDonald" <peggym@dartaero.com>
>>>> Cc: "Dale Trepanier" <dalet@dartaero.com>; "Jason Loader"
>>>> <jloader@eaglecopters.com>
>>>> Sent: Friday, June 24, 2005 3:16 PM
>>>> Subject: RE: D412-705-015
>>>>
>>>>
>>>>> I agree for a no-charge. We advertised that this panel works on
the
>>>>> 412

>>>> EP,
>>>> but it doesn't (on all).
>>>> Bill
>>>>
>>>> -----Original Message-----
>>>> From: Peggy McDonald [mailto:peggym@dartaero.com]
>>>> Sent: June 24, 2005 1:38 PM
>>>> To: Bill B
>>>> Subject: Fw: D412-705-015
>>>>
>>>>
>>>> I am await your OK Bill.
>>>>
>>>> Peggy
>>>>
>>>> ----- Original Message -----
>>>> From: "Jason Loader" <jloader@eaglecopters.com>
>>>> To: "Bill Beckett (E-mail)" <billb@dartaero.com>; "Dale Trepanier
>>>> (E-mail)"
>>>> <dalet@dartaero.com>; "Roberto F (E-mail)" <robertof@dartaero.com>
>>>> Cc: "Peggy McDonald (E-mail)" <peggym@dartaero.com>; "David
Shepherd
>>>> (E-mail)" <davids@dartaero.com>
>>>> Sent: Friday, June 24, 2005 1:35 PM
>>>> Subject: RE: D412-705-015
>>>>
>>>>
>>>> > RE: NCR 903
>>>>>
>>>>> Gerald Trudelle asked if it would be possible to have a
>>>>> complimentary
>>>>> D3256-041 access panel sent to him to replace the one he altered
to
>>>> rework
>>>>> the installation (D412-705-015 B21654). He would like to have the
>>>>> new
>>>>> panel
>>>>> on hand for when he receives the DS1 so the installation can be
>>>>> done
>>>>> exactly
>>>>> as per the DS1 (in case there is any deviation between what he
has
>>>> done
>>>> to
>>>>> the panel and what the DS1 tells him to do). If it is OK to send
>>>>> this
>>>>> panel
>>>>> it can be sent to:
>>>>>
>>>>> 14150 S.W.
>>>>> 127 Street

>>>> >> Miami, FL
>>>> >> 33186
>>>> >> ATTN: Gerald Trudelle
>>>> >> Ph. (305)232 4496
>>>> >>
>>>> >> This is for their Bell 412 S/N 36358
>>>> >>
>>>> >> Roberto, I sent a fax copy of a revised IIN for this kit with
some
>>>> notes
>>>> I
>>>> >> added to clarify the installation. I will be leaving the office
at
>>>> noon,
>>>> > but
>>>> >> you can still reach me by phone with any questions.
>>>> >>
>>>> >> Thanks everyone
>>>> >>
>>>> >> Jason
>>>> >> -----Original Message-----
>>>> >> From: Jason Loader [mailto:jloader@eaglecopters.com]
>>>> >> Sent: Thursday, June 23, 2005 10:53 AM
>>>> >> To: Bill Beckett (E-mail); Dale Trepanier (E-mail)
>>>> >> Cc: Peggy McDonald (E-mail); David Shepherd (E-mail)
>>>> >> Subject: D412-705-015
>>>> >>
>>>> >> Miami Dade ordered an EZ Access kit for their 412 EP. The 412 EP
>>>> >> has
>>>> >> a
>>>> >> larger driveshaft coupler and therefore the driveshaft tunnel had
>>>> >> to
>>> be
>>>> >> modified to fit it. Because of this modification the access panel
>>>> >> will
>>>> not
>>>> >> install exactly as per the current IIN. We now have a 412 EP
>>>> >> available
>>>> >> here
>>>> >> at Eagle that I can work with to rework the IIN for the
>>>> >> 212-061-903-177/-199
>>>> >> tunnels. I will need a D412-705-015 kit expedited to Eagle so I
can
>>>> rework
>>>> >> the installation and the customer can carry on with their
>>>> >> installation
>>>> of
>>>> >> the EZ Access kit.
>>>> >>
>>>> >> Jason
>>>> >>